

505

Split B

DART AEROSPACE LTD	Work Order :	23925B
Description: Cap	Part Number:	D2855
Drawing: D2855 Rev. A	Qty:	100

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	AR	05/09/05	100
2	PURCHASING	Issue P/O: 2008431 Cast per Dwg D2855 Material release note required	W	05/08/05	100
3	RECEIVING	Receive and ensure material note is attached	CJ	05/09/05	100
4	QC	Inspect Level 6 Ensure material release note is attached	J	05/10/05	100
5	METAL	Drill as per Dwg D2855 using DT 8235 Open holes to 19/64"	JB	05/10/05	100
6	METAL	Deburr and Tumble	SB	05/10/05	100
7	QC	Inspect Level 7	J	05/10/05	100
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FC	05/10/06	50
9	QC	Inspect Level 3	MM	05/10/06	50
10	STORES	Pick: Qty Part Number Description Batch 2 ALS7-1032-225 or Insert M14576 AKS7-1032-225 or ALS4-1032-225 or AKS4-1032-225	FC	05/10/06	50
11	METAL	Install Inserts as per Dwg D2855	FC	05/10/06	50
12	QC	Inspect Level 7	MM	05/10/06	50
13	STORES	Identify and Stock	MM	05/10/06	50
14	EXPEDITING	Close W/O Cost / Part 14.69 245 05/10/07 (50)	CP	05/10/07	50

PTO

Rev	Date	Change	Revised By	Approved
A	99.01.04	New Issue (was D2575 Rev. E)	DM	
B	00.06.22	Added receiving step & removed P/O for powder coat	EC	

RELEASED

EC JUN 26 2000

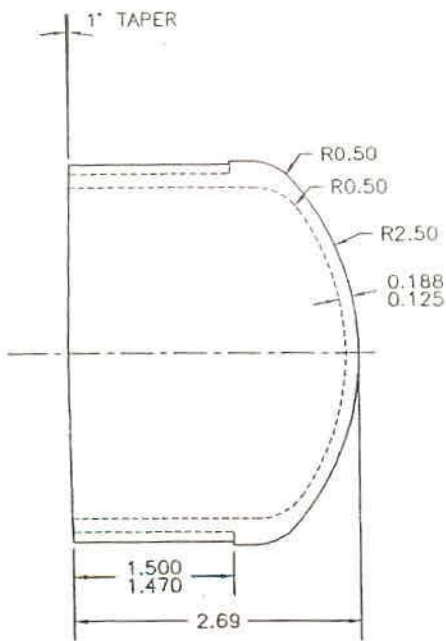
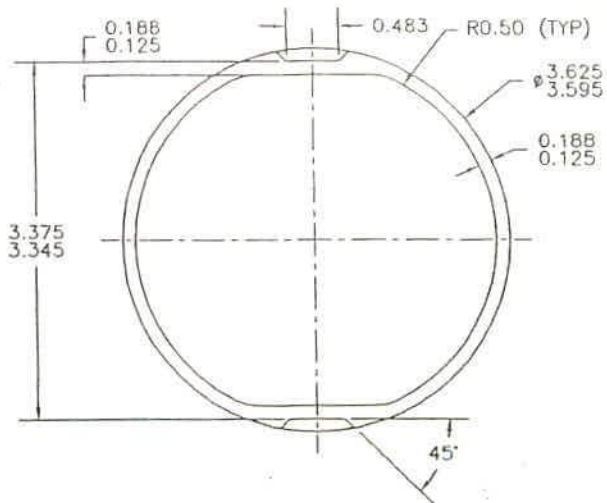
DART



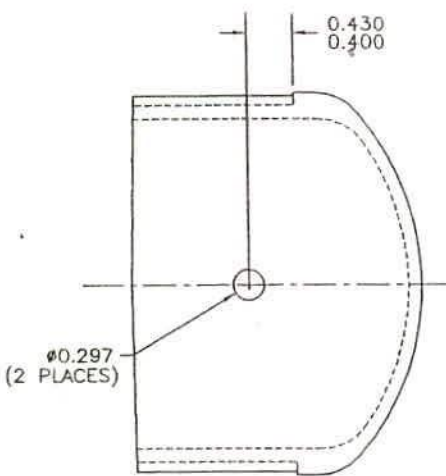
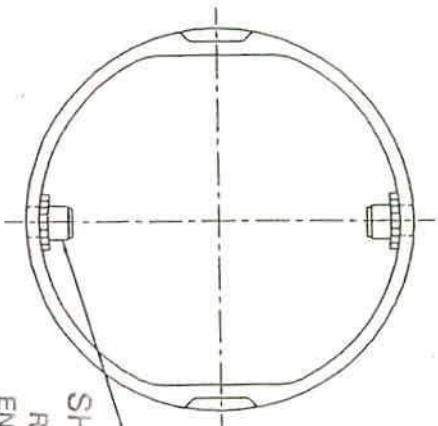
DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED	DRAWING NO.	D2855	SHEET 1 OF 1
DATE		TITLE	CAP	SCALE
98.12.12				NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)		

RELEASED
198.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT) (2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AEC
WITH-OUT NOTICE

WORK ORDER

NO. 23945